



## D3624-2 BUBBLE WINDOW

NOTES: (1) WATER/ AIR / BI EXIGI AS & CLEAR CAST ACBVI IC SHEET BEBI B-391 TYPE 1 GRADE C

- 1) MATERIAL: 1/4" CLEAR CAST ACRYLIC SHEET, 30" X 11", CHALK C

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 0118 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX

6) IDENTIFICATION: ENGRAVE P/N & B/N ON FLANGE WITHIN 0.25" OF BUBBLE. USE 0.125" LETTERS TO MAX DEPTH OF 0.005".

7) WEIGHT: 2.95 lbs

8) FORM PER DT8953 AND QSI 022

FORMING PROCESS: (a) DRAPE OVER DT8953 MOLD  
(b) HEAT TO 290°F  
(c) VACUUM FORM TO SPECIFIED HEIGHT  
(d) LET COOL TO AT LEAST 100°F BEFORE HANDLING  
(e) TRIM FLANGE USING DT8954

OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425  
0.117 TO 0.188 THICK (STOCK, REF DART SPEC MACRYLIC-S)

REV.	DESCRIPTION	BY	DATE
D	REDRAW, REFORMAT, RMV SHAPE TOOL, ADD SEC B-B (2C8) & C-C (2C3), ADD FLANGE & WALL & WALL ANGLE DIMS, UPDATE MATT SPEC (1B8)	CP	08.03.12
C	ADD TOOL TO CONTROL BUBBLE SHAPE	CP	07.06.27
B	11.0" DEPTH WAS 12.0"	CP	07.05.24
A	NEW ISSUE	CP	07.06.27
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DESIGN		DRAWING NO.	REV. D
DRAWN		D3624	SHEET 1 OF 2
CHECKED		TITLE	SCALE
MFG. APPR.		BUBBLE WINDOW (A119)	NTS
APPROVED			
DE APPR.			
DATE	08.03.12	<b>COPYRIGHT © 2007 BY DART AEROSPACE LTD</b>	
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